

Date: Friday, 12/21/2007 7:27:38 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 36518		
Estimate Number	: 10346		
P.O. Number	: NIA	Part Number	: D2596
This Issue	: 12/21/2007 S.O. No. : NIA	Drawing Number	: D2596 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NA Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 36328	Material	: NIA
Written By	: _____	Due Date	: 1/20/2008
Checked & Approved By	: <u>07/12/21</u>	Qty:	4 Um: Each
Comment	: Est: D 99-02-02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D25003100	Ext'n - 'I' Beam Web 4"
-----	-----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	<u>33940</u>

(4)

SL 8-1-8

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

SL 8-1-8

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

SL 8-1-8

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

BE 08/01/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 08/04/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 36518

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 8-1-8

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④
2008/01/09

Job Completion



2008/1/8

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

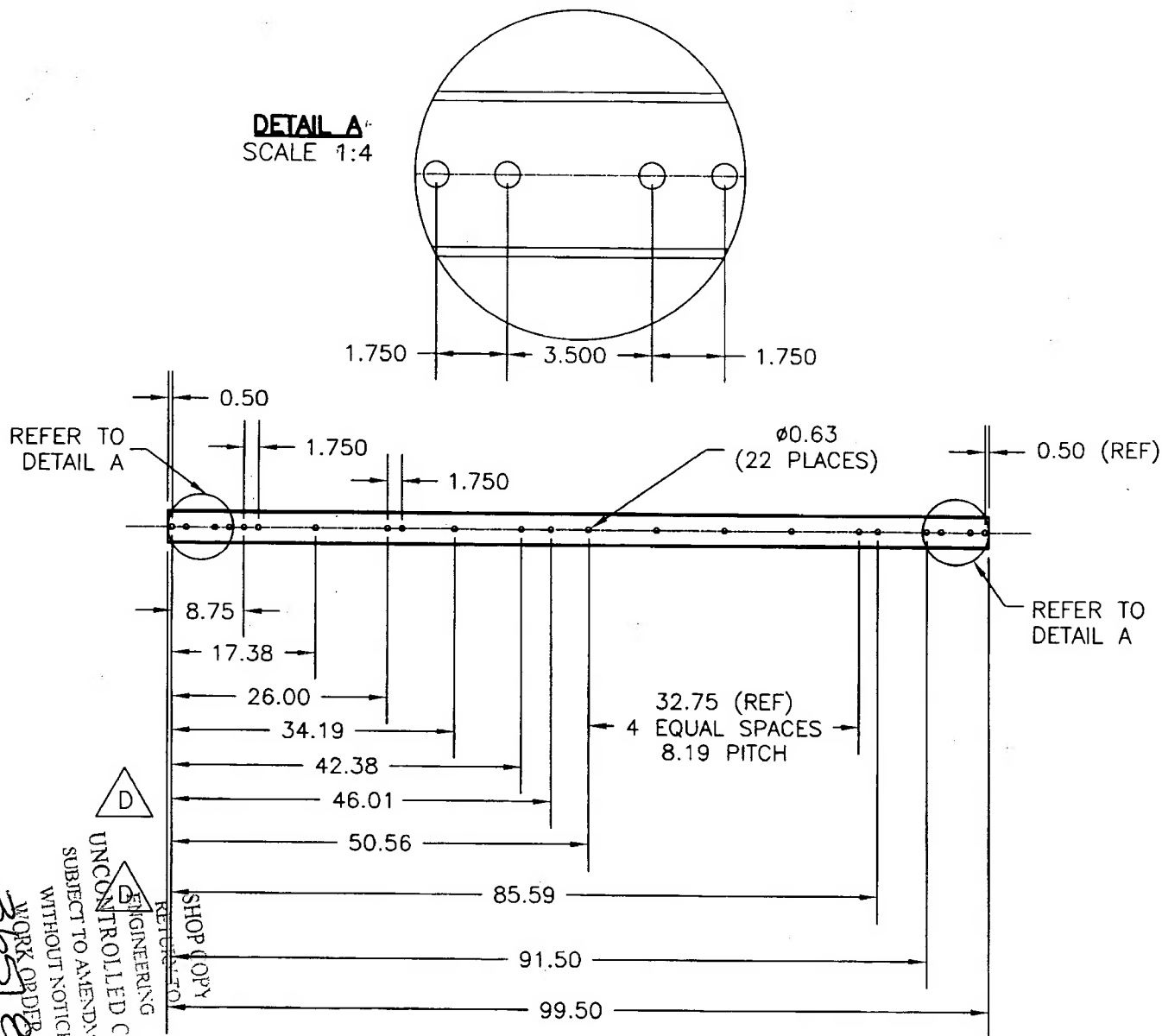
NOTE: Date & initial all entries

DART

RELEASED
07.06.18

DESIGN	DH	DRAWN BY	DH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. D
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	SHEET 1 OF 1
DATE	07.04.17	TITLE	205 WEB	D2596	SCALE
A	96.09.16	NEW ISSUE			1:20
B	97.07.23	Ø0.63 HOLE WAS Ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.